

538

|                                     |                     |             |
|-------------------------------------|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>           | <b>Work Order:</b>  | 24019       |
| <b>Description:</b> Clamp           | <b>Part Number:</b> | D3440-3     |
| <b>Dwg:</b> D3440 Rev. A page 2     | <b>Qty:</b>         | 20          |
| Replaces Premier P/N: B67-43001-309 |                     | Page 1 of 1 |

| Step | Location | Procedure   | By  | Date     | Qty |
|------|----------|---|-----|----------|-----|
| 1    | DC       | Issue Traveler  | AB  | 05/08/12 | 20  |
| 2    | MV       | Cut blank: 1.250" x 1.250" x 3.950" long<br>Material: 6061-T6 or 6061-/651/T6510/T6511/T62 Bar<br>(QQ-A-225/8)<br>(M6061T6B1.250x01.250)<br><b>Identify for D3440-3</b> Batch: M16954 | SA  | 05.08.19 |     |
| 3    | MV       | Machine as per Folio FA538 and Dwg D3440 Dwg Rev: A<br><b>Identify as D3440-3</b> Folio Rev: AA   | BG  | 05.08.20 | 20  |
| 4    | QC2      | Inspect parts as they come off the CNC machine  | BG  | 05.08.20 | 20  |
| 5    | QC8      | Second check  | CR  | 05/08/20 | 20  |
| 6    | MV       | Deburr  | BG  | 05.08.20 | 20  |
| 7    | FP       | Chemical Conversion Coat as per QSI 005 4.1   | FF  | 05.08.27 | 20  |
| 8    | FP       | Powder Coat Green Sandtex (Ref: 4.3.5.8) per QSI 005 4.3  | FC  | 05.08.29 | 20  |
| 9    | QC3      | Inspect Powder Coat   | MM  | 05.08.29 | 20  |
| 10   | ST       | Identify and Stock  | CL  | 05/08/30 | 20  |
| 11   | AC       | Cost / part: 12.75  | SAC | 05.08.31 | 20  |
| 12   | DC       | Close W/O 12.75<br>Inspect Level 21   | CR  | 05/08/31 | 20  |

| Rev | Date     | Change    | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A   | 05.07.13 | New issue | KJ/JLM     |          |

RELEASED  
05.07.13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

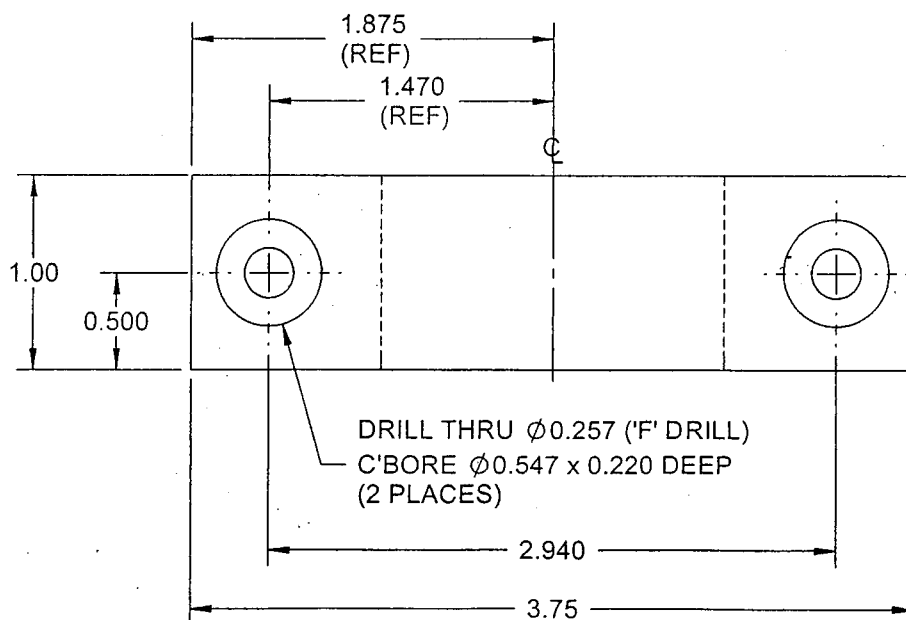
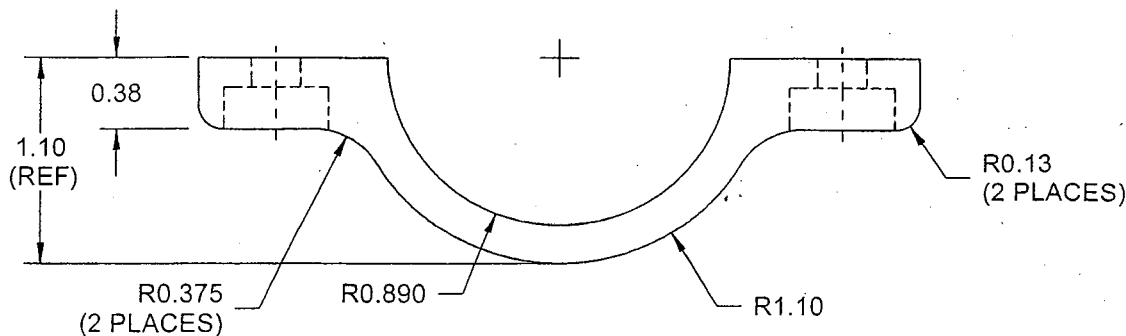
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LS Date: 05.08.31

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**PRELIMINARY ISSUE**

|                         |                    |  |                        |
|-------------------------|--------------------|--|------------------------|
| DESIGN <i>13</i>        | DRAWN BY <i>13</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED                 | APPROVED           | DRAWING NO.<br><b>D3440</b>                              | REV. A<br>SHEET 2 OF 4 |
| DATE<br><b>05.06.02</b> |                    | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |



**D3440-3 CLAMP**  
**SUPERCED PREMIER P/N B67-43001-309**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT MILITARY GREEN (4.3.5.XX) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**SHOP COPY**

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WITHOUT NOTICE

**WORK ORDER**

**NO. 24019**

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 09, 2005  
11:33 am

|                   |            |                              |                |
|-------------------|------------|------------------------------|----------------|
| Work Order No     | : 0024019  | Department Code:             |                |
| Project Name      | : D3440-3  | Burden Flags                 | : NNNNNNNN     |
| Project For       | : WK538    | WO Status                    | : Open         |
| Work Order Type   | : Main     | Invoice State                | : Not Invoiced |
| Main WO Number    | :          | Invoice Date                 | :              |
| House Part Number | : D3440-3  | Invoice Number               | :              |
| Description       | : Clamp    | Invoice Amount               | : 0.00         |
| Manufactured      | : Yes      |                              |                |
| Amount Req'd      | : 20       | Order Entry No               | :              |
| Amount Done       | : 0        | OE Value                     | : 0.00         |
| Start Date        | : 08-09-05 |                              |                |
| Est Finish Date   | : 09-28-05 | Est Margin                   | : 0.000%       |
| Act Finish Date   | :          | Actual Margin                | : 0.000%       |
| Drawings Req'd    | : No       |                              |                |
| Ok for Approval   | :          |                              |                |
| Approval Rec'd    | :          | \$0 Posted to Finished Goods |                |

|                   | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours         | 0.00      | 0.00   | 0.00   |        |         |
| CNC               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours       | 0.00      | 0.00   | 0.00   |        |         |
| Misc.             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost        | 0.00      | 0.00   | 0.00   |        |         |
| Margin            | 0.000     | 0.000  |        |        |         |
| Selling Cost      | 0.00      | 0.00   |        |        |         |

|                        | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00      | 0.00   |
| Profits/(Loss)         | 0.00      | 0.00   |

DWG 03110 W/O ~~24019~~  
24019

REV A P. No. D3440-3

| Dim.             | Tol.   | Actual Dim. | Accept | Rejct    | Method | Comments |
|------------------|--|-------------|--------|----------|--------|----------|
| 1.10 (REF)       | $\pm .030$   | 1.10        | /      |          |        |          |
| .38              | $\pm .030$   | .380        | /      |          |        |          |
| R.375            | $\pm .01$  | .375        | /      |          |        |          |
| R.850            | $\pm .01$  | .800        | /      |          |        |          |
| 1.00             | $\pm .030$   | .976        | /      |          |        |          |
| .500             | $\pm .005$   | .498        | /      |          |        |          |
| 1.875            | $\pm .010$   | 1.875       | /      |          |        |          |
| 1.470            | $\pm .010$   | 1.470       | /      |          |        |          |
| 2.940            | $\pm .010$   | 2.940       | /      |          |        |          |
| 3.75             | $\pm .010$   | 3.752       | /      |          |        |          |
| $\emptyset .257$ | $\begin{smallmatrix} +.005 \\ -.001 \end{smallmatrix}$ | .258        | /      |          |        |          |
| Chore .547       |  |             |        |          |        |          |
| .220 Deep        |  | .220        | /      |          |        |          |
| Measured by      | SD   | Audited by  | SL     | 03.08.20 |        |          |
| 03.08.19         |  |             |        |          |        |          |

